

Thursday, 11/23/2006 11:53:10 AM
Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SADDLE FITTING, FWD (OUTBOARD/INBOARD)
Job Number	: 29661	Part Number	: D2572
Estimate Number	: 10531	Drawing Number	: D2572 REV E
P.O. Number	: N/A	Project Number	: N/A
This Issue	: 11/23/2006 S.O. No. : N/A	Drawing Revision	: E
Prsht Rev.	: NC	Material	: P/A
First Issue	: N/A Type : MACHINED PARTS	Due Date	: 12/20/2006
Previous Run	: 29511	Qty:	12 Um: Each
Written By	: <u>[Signature]</u>		
Checked & Approved By	: <u>[Signature]</u>		
Comment	: Est: 1 02.10.02 Re-format; Change to Dwg Rev. D & incorporated D2572KJ		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6101005	7075-T7351 8.25X5.0X2.5
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)

7075-T7351 8.25X5.0X2.5

Make from D6101-005 billet for D2572

Ensure that grain is along 5.00" length

Batch No: 325351

5 06/11/29 x 12 (+1 SA 06/12/03)

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

Program Batch No. 324661 Double check by: J.G 06/11/29

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per

Folio FA051 and inspect per attached Dimension Sheets

3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets

4-Deburr and remove all machining marks

5-Tumble to remove shap edges.

9ml/5 / SA 06.12.03

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE

Machine keyway as per dwg D2571 & D2572

9ml/5 / SA 06.12.03

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2572 PAR #: N/A Fault Category: Prod / Machine NCR: Yes No DQA: Le Date: 06/12/04
 QA: N/C Closed: _____ Date: _____

NCR: <u>29661</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/12/04	3.0	Slot is .070 off-center, setup on milling machine moved.	<u>AB</u> <u>QSP</u>	Scrap destroy & replace. Inspect XLO mill for slack. XLO operatable.	<u>SD</u> 06/12/04	<u>06/12/14</u>	<u>AB</u> <u>QSP</u>	<u>06/12/04</u>

NOTE: Date & initial all entries

Date: Thursday, 11/23/2006 11:53:10 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

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Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

EN/SD 06.12.02

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

J.L 06/12/15

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

am/512

(12)

7.0

POWDER COATING

POWDER COATING



M102391



(12)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M.R/am 06/12/21

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

RU 6/12/21

(12)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 51479 EB

6/12/21

RU 6/12/21

(12)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



(12)

Comment: FINAL INSPECTION/W/O RELEASE

LD 06/12/22

Job Completion



U 06.12.22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	29661
Description: Saddle, Fwd Inboard	Part Number:	D2572
Inspection Dwg: D2572 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.438	0.443	DT8682	0.440	0.440	0.440	0.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.749	1.750	1.750	1.750		
E	7.990	8.010		7.999	7.999	7.999	7.999		
F	0.490	0.510		0.502	0.503	0.503	0.500		
G	0.257	0.262	DT8683	0.258	0.258	0.258	0.258		
H	0.375	0.380	DI8684	0.377	0.377	0.377	0.377		
I	0.490	0.510		0.498	0.498	0.497	0.498		
J	1.174	1.184		1.178	1.178	1.178	1.178		
K	0.558	0.578		0.565	0.565	0.566	0.564		
L	1.174	1.184		1.178	1.178	1.179	1.178		
M	1.490	1.500		1.494	1.495	1.495	1.495		
N	2.495	2.505		2.499	2.500	2.500	2.500		
O	3.869	3.879		3.873	3.872	3.871	3.872		
P	0.115	0.135		0.126	0.125	0.125	0.127		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.249	0.249	0.249	0.251		
S	0.115	0.135		0.133	0.132	0.132	0.132		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		0.243	0.242	0.240	0.241		
W	0.115	0.135		0.130	0.130	0.130	0.130		
X	0.307	0.312		0.309	0.309	0.310	0.308		
Y	0.760	0.765		0.765	0.765	0.765	0.765		
Z	0.352	0.372		0.367	0.366	0.367	0.367		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.630	0.630	0.630	0.630		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.250	0.249	0.247	0.249		
AE	1.375	1.395		1.382	1.382	1.382	1.382		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.252	0.250	0.249	0.251		
AI	2.000	2.020							
AJ	0.023	0.043		0.030	0.030	0.030	0.030		
Accept/Reject									

Measured by:	JML
Date:	06/12/01

Audited by:	J.L
Date:	06/12/15

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD	Work Order: 29661
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				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.438	0.443	DT8682	0.440	.438	.434	.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.756	1.750	1.760	1.748		
E	7.990	8.010		7.999	7.999	8.000	7.998		
F	0.490	0.510		0.500	.500	.486	.486		
G	0.257	0.262	DT8683	0.258	.258	.258	.258		
H	0.375	0.380	DT8684	0.377	.376	.376	.376		
I	0.490	0.510		0.498	.495	.500	.500		
J	1.174	1.184		1.178	1.175	1.175	1.179		
K	0.558	0.578		0.565	.567	.567	.567		
L	1.174	1.184		1.178	1.175	1.175	1.178		
M	1.490	1.500		1.495	1.493	1.493	1.493		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.871	3.871	3.874	3.874		
P	0.115	0.135		0.126	.126	.126	.126		
Q	0.115	0.135		0.135	.135	.135	.135		
R	0.240	0.260		0.257	.250	.250	.251		
S	0.115	0.135		0.133	.133	.129	.133		
T	0.178	0.198		0.188	.188	.188	.188		
U	2.940	2.980		2.960	2.961	2.960	2.960		
V	0.230	0.250		0.242	.243	.240	.242		
W	0.115	0.135		0.130	.128	.129	.128		
X	0.307	0.312		0.309	.312	.312	.313		
Y	0.760	0.765		0.760	.761	.761	.761		
Z	0.352	0.372		0.365	.365	.364	.365		
AA	0.470	0.530		0.500	.500	.500	.500		
AB	0.615	0.635		0.630	.630	.629	.628		
AC	0.053	0.073		0.063	.063	.063	.063		
AD	0.240	0.260		0.249	.245	.248	.248		
AE	1.375	1.395		1.385	1.386	1.386	1.385		
AF	0.115	0.135		0.135	.134	.134	.134		
AG	0.240	0.280		0.260	.260	.255	.253		
AH	0.240	0.260		0.250	.250	.248	.248		
AI	2.000	2.020							
AJ	0.023	0.043		0.030	.030	.030	.030		
Accept/Reject									

Measured by: <i>gml SD</i>	Audited by: <i>J.L</i>
Date: 06.02.02	Date: 06/12/15

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
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Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.438	0.443	DT8682	.439	.439	.439	.439		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.000	7.999	7.999		
F	0.490	0.510		.500	.497	.496	.498		
G	0.257	0.262	DT8683	.258	.258	.258	.258		
H	0.375	0.380	DT8684	.376	.376	.376	.376		
I	0.490	0.510		.501	.500	.500	.500		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.566	.567	.568	.566		
L	1.174	1.184		1.175	1.179	1.179	1.179		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.501	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.874	3.874		
P	0.115	0.135		.126	.126	.126	.126		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.250	.248	.250	.248		
S	0.115	0.135		.128	.128	.128	.128		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		.241	.241	.241	.241		
W	0.115	0.135		.125	.125	.125	.126		
X	0.307	0.312		.312	.312	.311	.312		
Y	0.760	0.765		.761	.761	.761	.761		
Z	0.352	0.372		.363	.364	.364	.363		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.624	.626	.623	.624		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.250	.250	.251	.250		
AE	1.375	1.395		1.386	1.387	1.386	1.385		
AF	0.115	0.135		.135	.135	.134	.135		
AG	0.240	0.280		.25	.25	.25	.25		
AH	0.240	0.260		.251	.251	.250	.251		
AI	2.000	2.020							
AJ	0.023	0.043		0.036	0.030	0.030	0.030		
Accept/Reject									

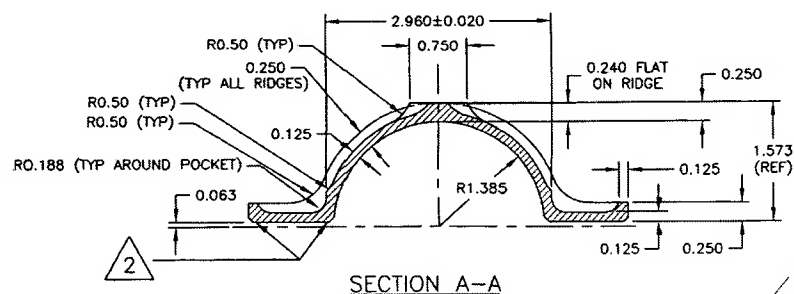
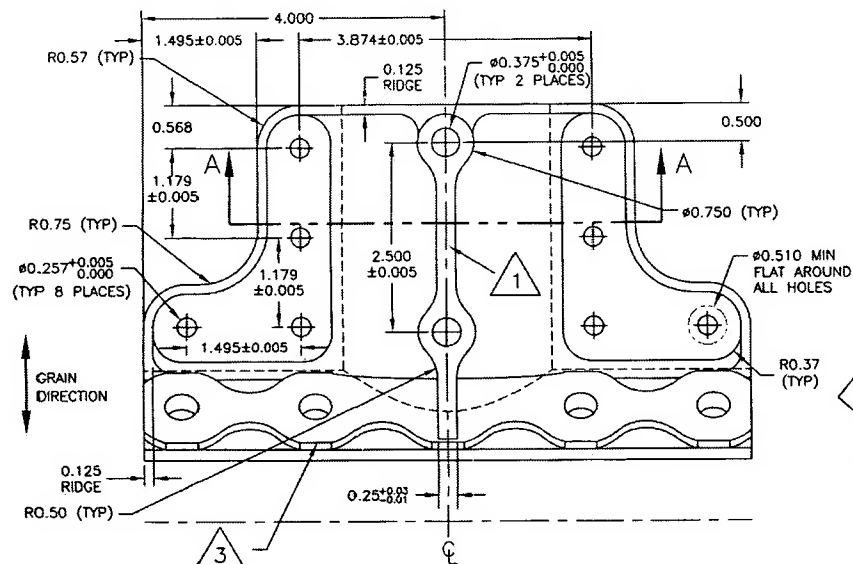
Measured by:	SD
Date:	06.12.02

Audited by:	J.L
Date:	06/12/15

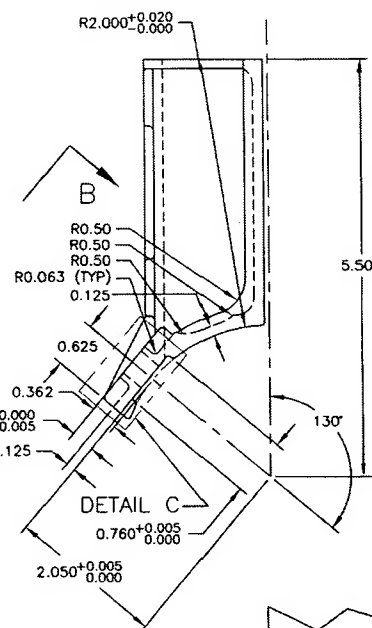
Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

RELEASED

05.12.06



SECTION A-A



0.438±0.005
-0.000
(TYP 4 PLACES)

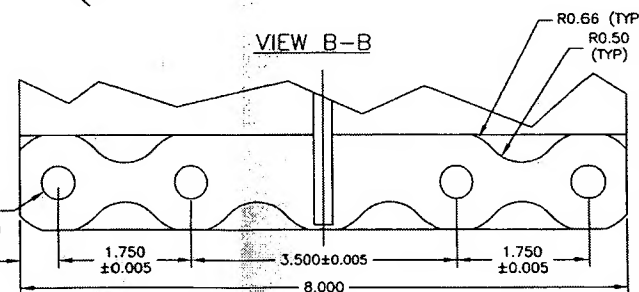
0.060
R0.025 (TYP)
4 (TYP)

NOTES

MATERIAL: 7075-T7351 (QQ-A-250/12)
(REF DART SPEC. D6102-003)
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER
DART QSI 005 4.3
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
2 CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
3 CHAMFER 0.063 x 45° ALL AROUND
4 CHAMFER 0.033 x 45° (SEE DETAIL C) E

VIEW B-B



E	05.07.13	ADD CHAMFER ON RIDGE NOTE 4
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE
DESIGN	DS	DRAWN BY PH
CHECKED	#	APPROVED #
DATE	05.07.13	DRAWING NO. D2572
		TITLE INNER FWD SADDLE
		REV. E SHEET 1 OF 1 SCALE 2:3

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DETAIL C
SCALE 2:1